

(10) **Patent No.:** US 9,257,550 B2
(45) **Date of Patent:** Feb. 9, 2016

- (58) **Field of Classification Search**
CPC H01L 29/1608; H01L 29/66068;
H01L 29/7802; H01L 29/7813; H01L 29/1095
See application file for complete search history.

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- Primary Examiner* — Jaehwan Oh

- (22) Filed: **Jun. 30, 2015**

(74) *Attorney, Agent, or Firm* — Allen, Dyer, Doppelt,
Milbrath & Gilchrist, P.A.

- (65) **Prior Publication Data**

US 2015/0325654 A1 Nov. 12, 2015

Related U.S. Application Data

- (62) Division of application No. 13/221,733, filed on Aug. 30, 2011, now Pat. No. 9,142,666.

- (30) **Foreign Application Priority Data**

Aug. 30, 2010 (IT) TO2010A0722

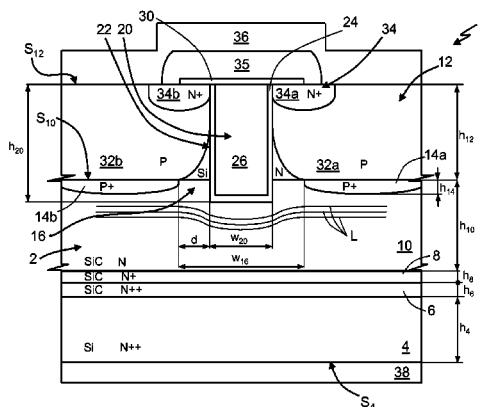
- (51) **Int. Cl.**
H01L 29/78 (2006.01)
H01L 29/423 (2006.01)
 (Continued)

- (52) **U.S. Cl.**
CPC ***H01L 29/7813*** (2013.01); ***H01L 21/02381***
(2013.01); ***H01L 21/02529*** (2013.01);
(Continued)

ABSTRACT

An embodiment of an integrated electronic device formed in a body of semiconductor material, which includes: a substrate of a first semiconductor material, the first semiconductor material having a first bandgap; a first epitaxial region of a second semiconductor material and having a first type of conductivity, which overlies the substrate and defines a first surface, the second semiconductor material having a second bandgap wider than the first bandgap; and a second epitaxial region of the first semiconductor material, which overlies, and is in direct contact with, the first epitaxial region. The first epitaxial region includes a first buffer layer, which overlies the substrate, and a drift layer, which overlies the first buffer layer and defines the first surface, the first buffer layer and the drift layer having different doping levels.

24 Claims, 13 Drawing Sheets



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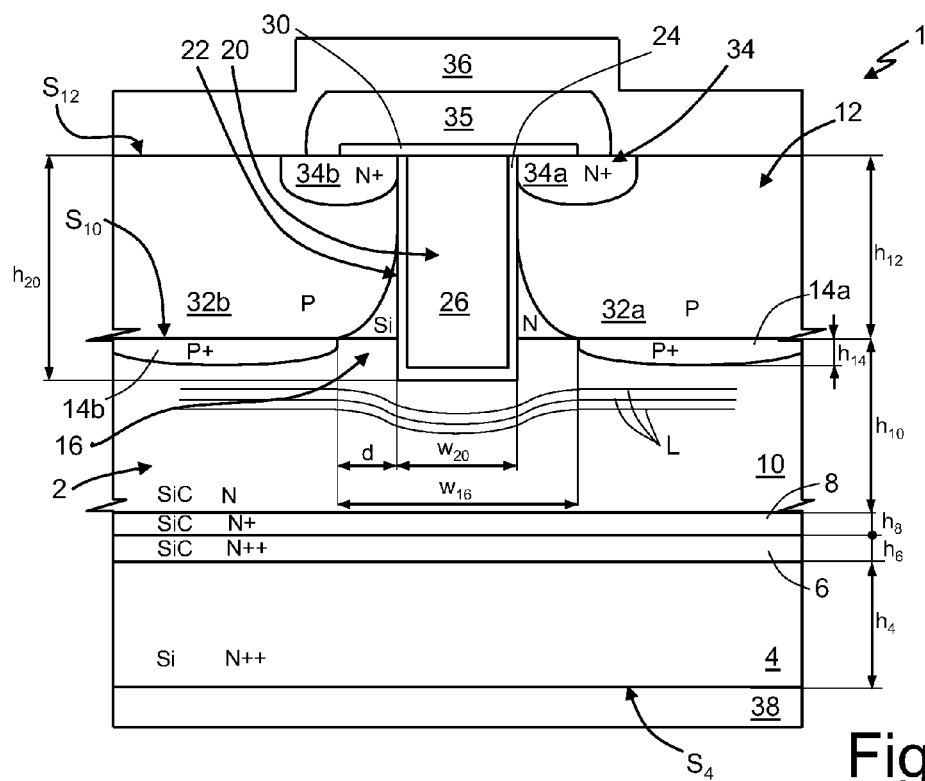


Fig.1

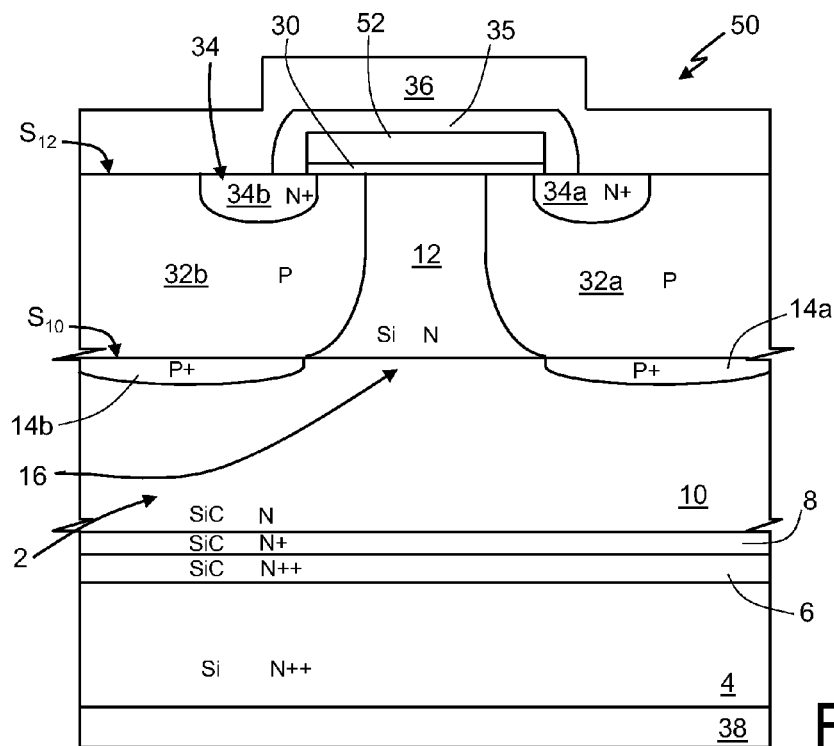


Fig.2

Fig.3

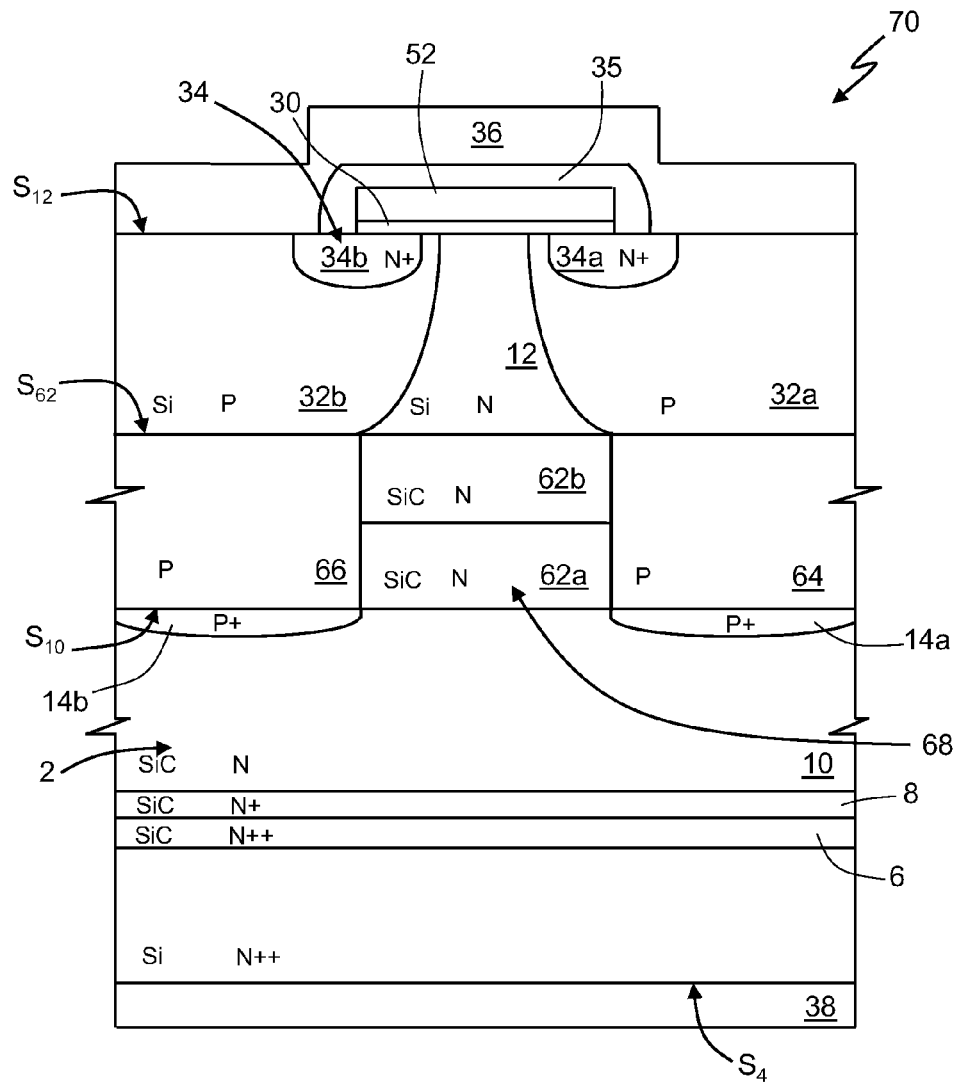


Fig.4

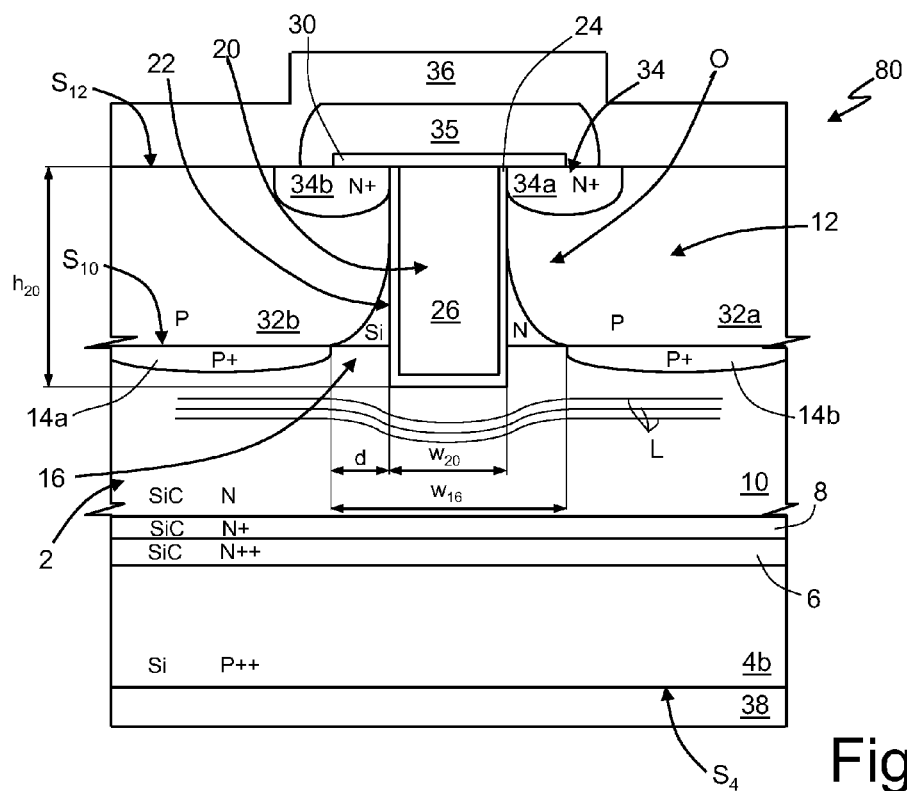


Fig.5

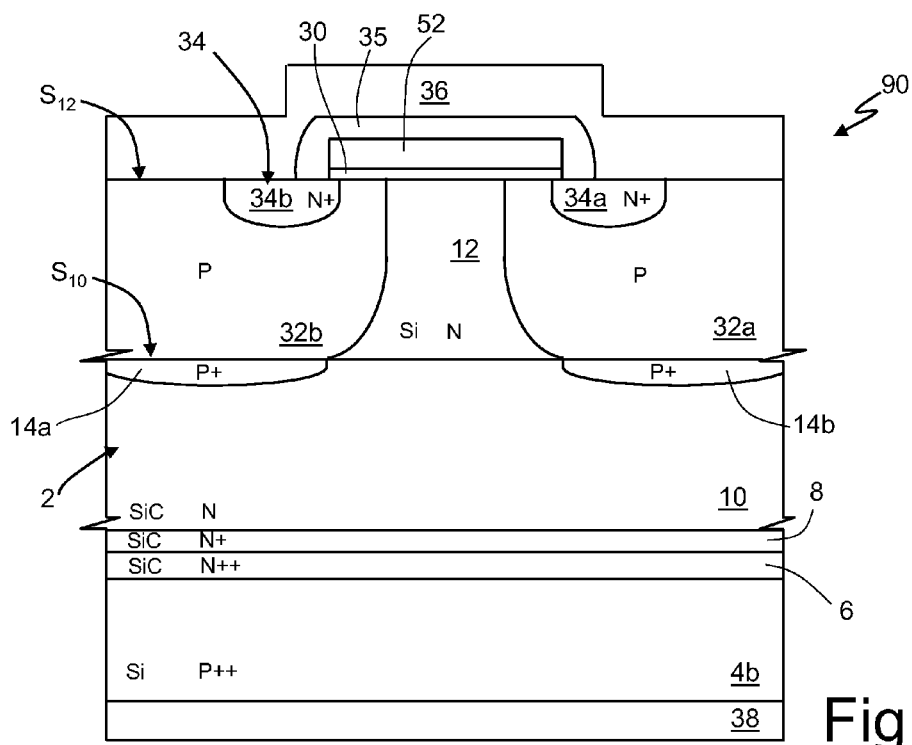


Fig.6

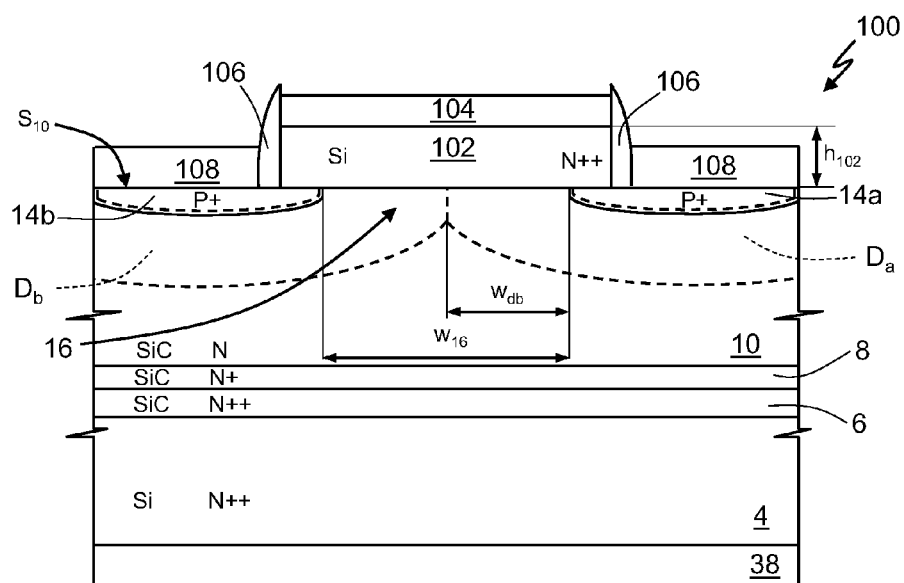


Fig.7

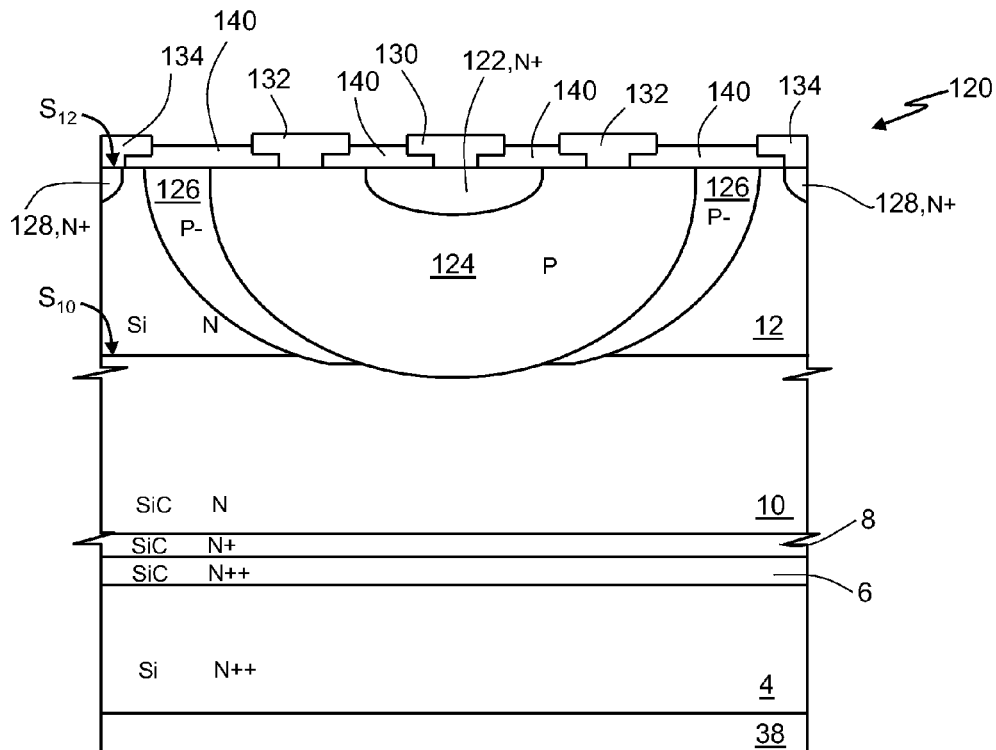


Fig.8

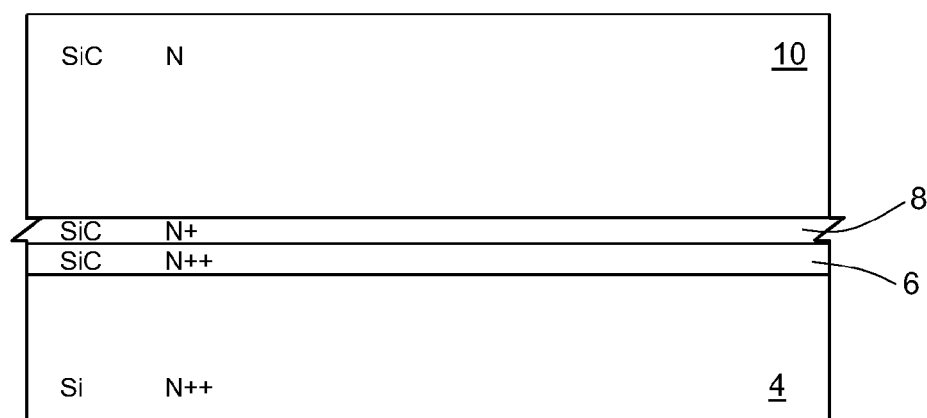


Fig.9

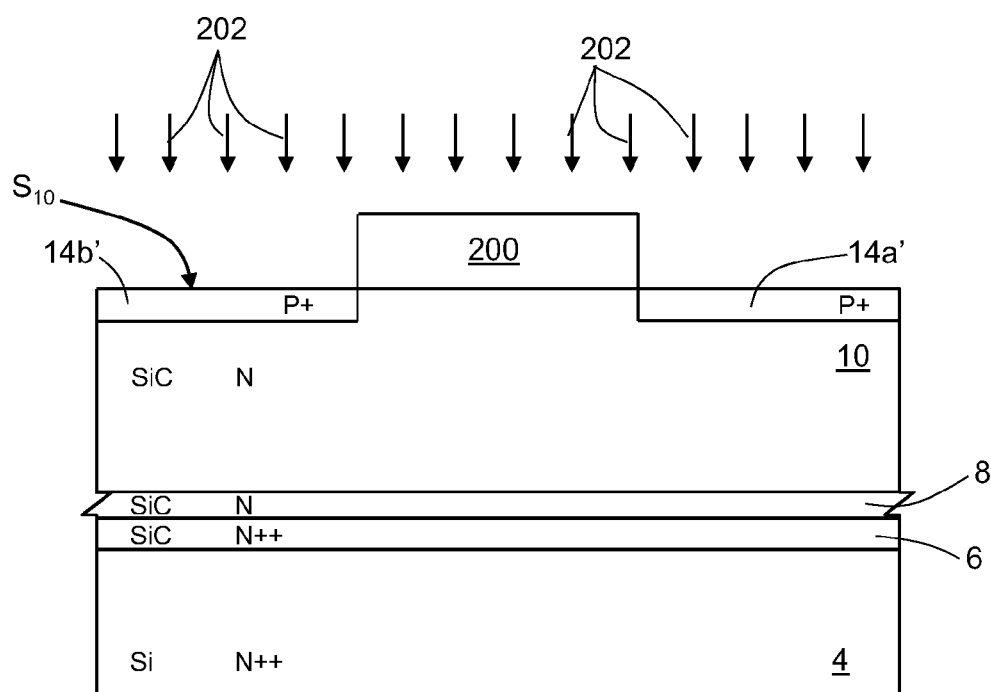


Fig.10

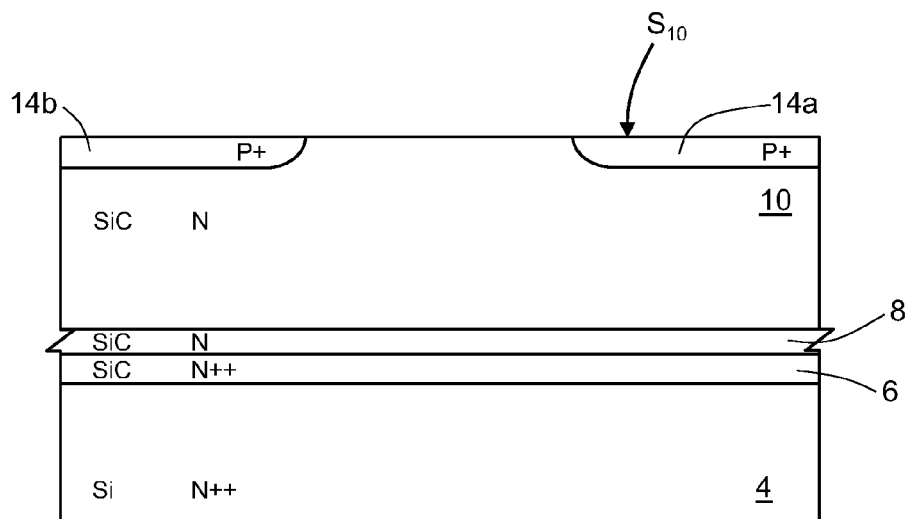


Fig.11

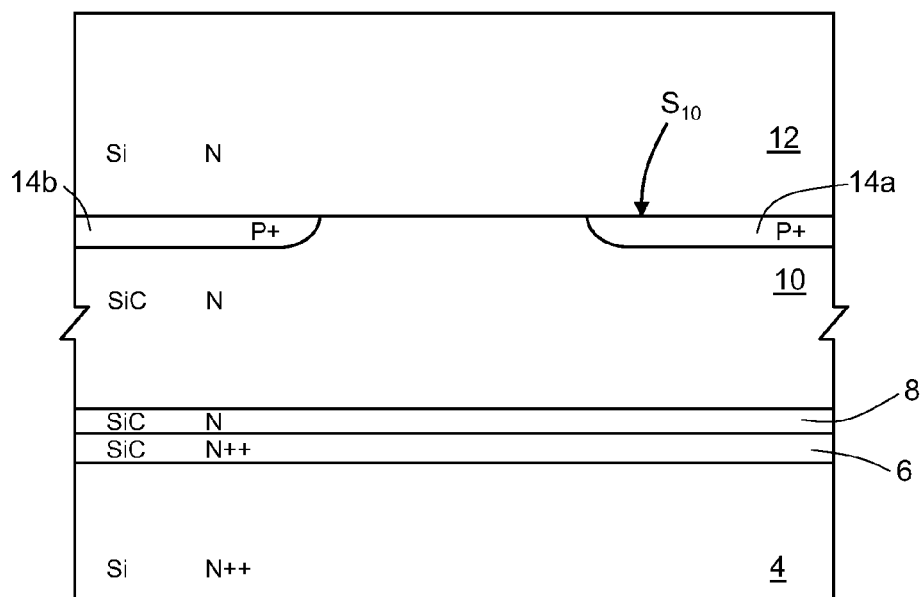


Fig.12

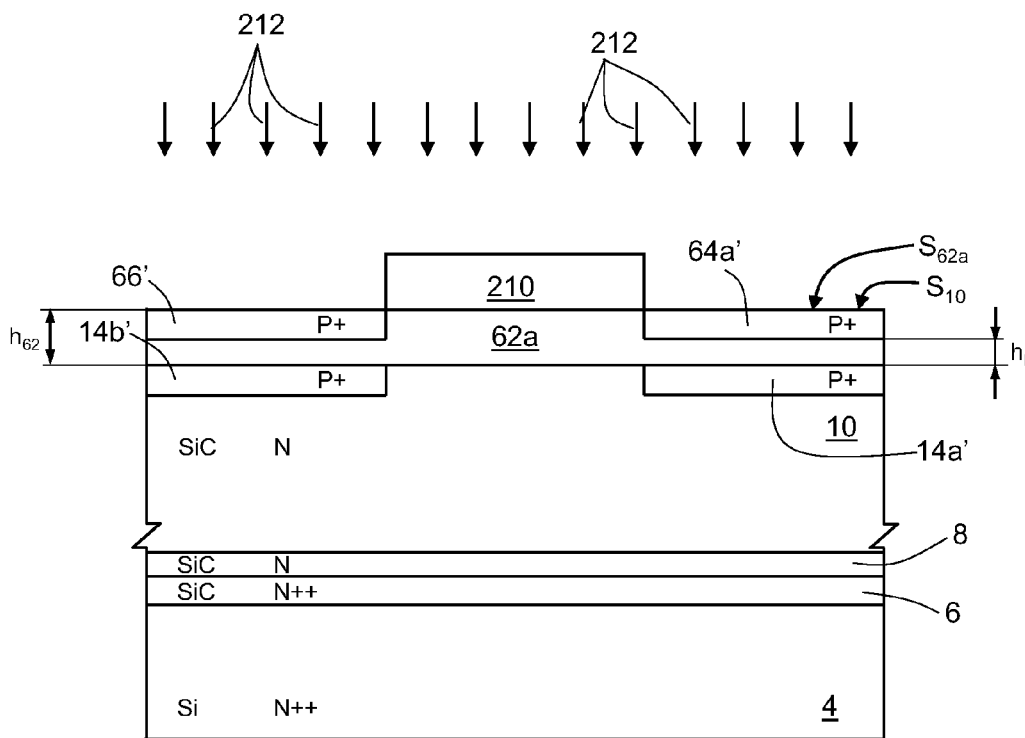


Fig.13

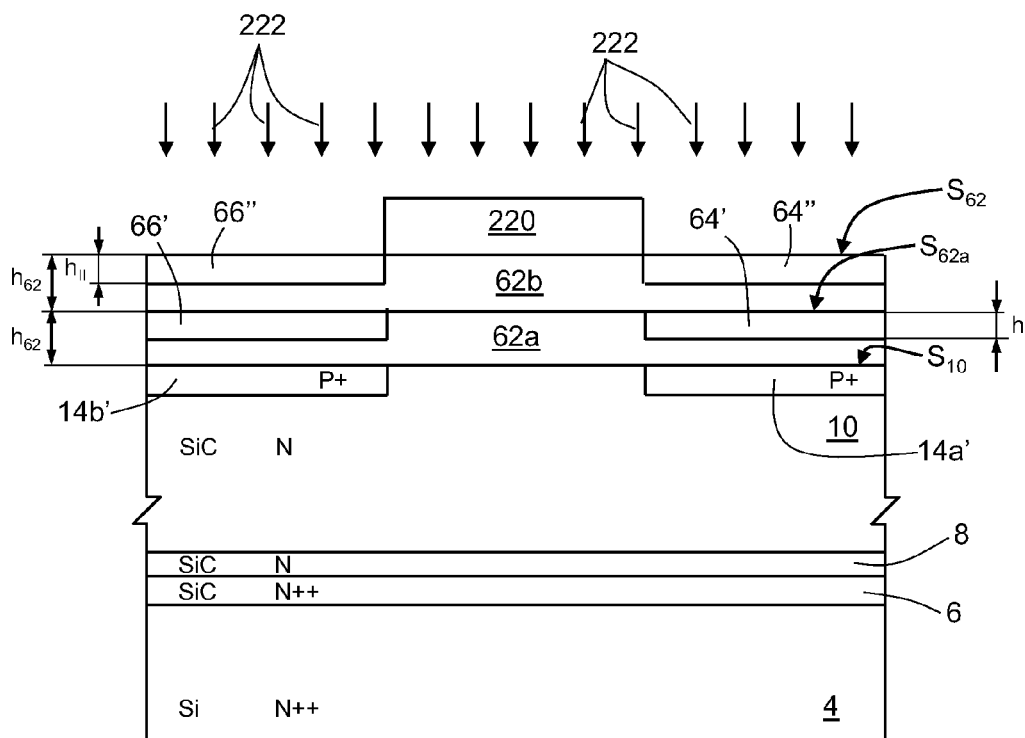


Fig.14

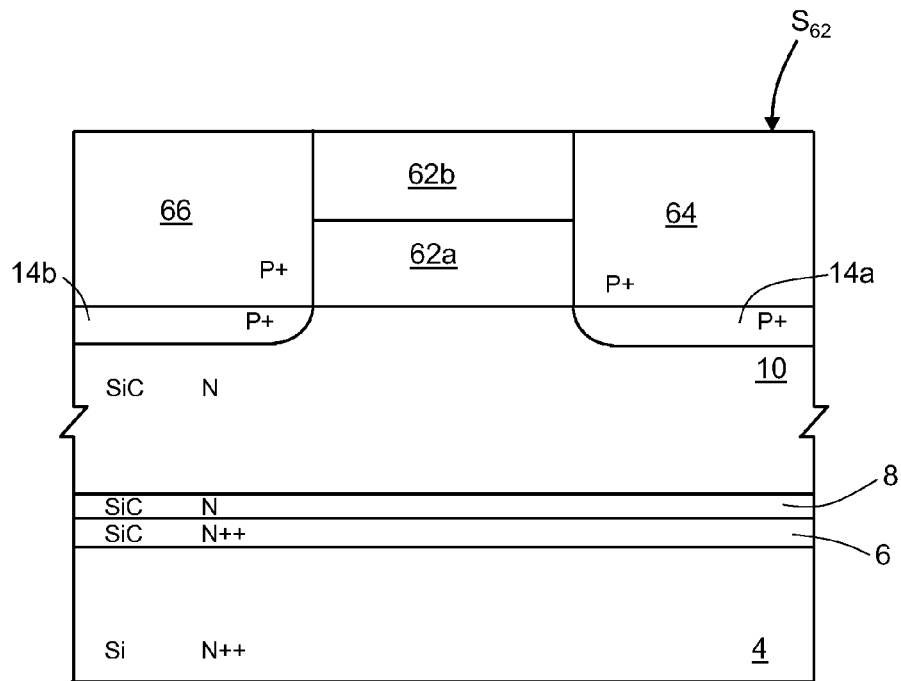


Fig.15

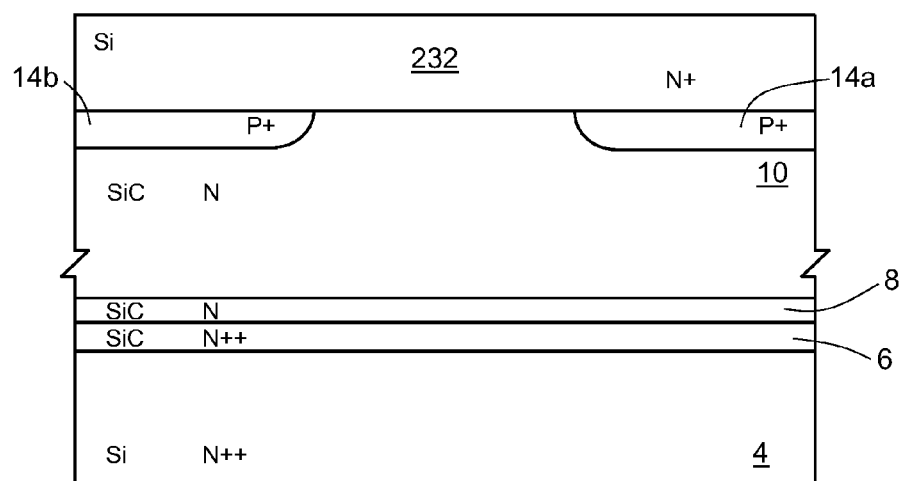


Fig.16

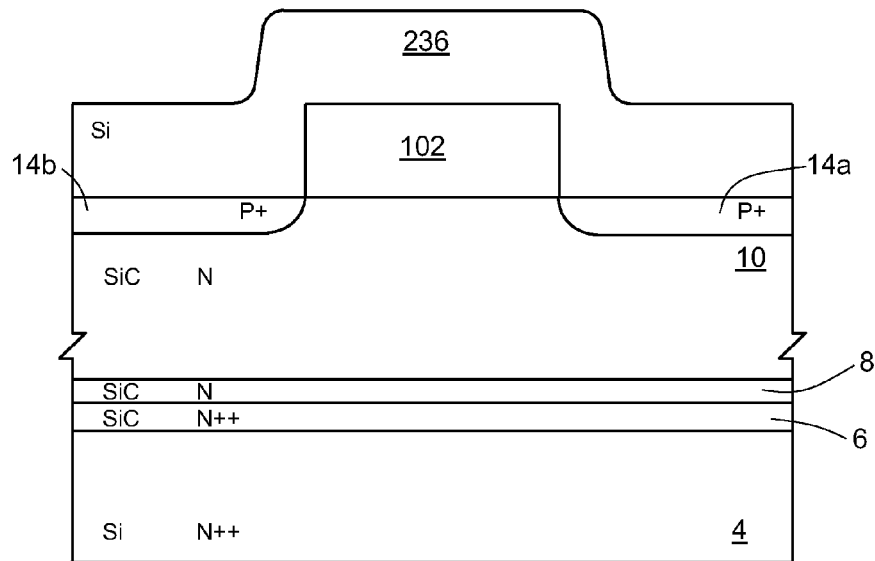


Fig.17

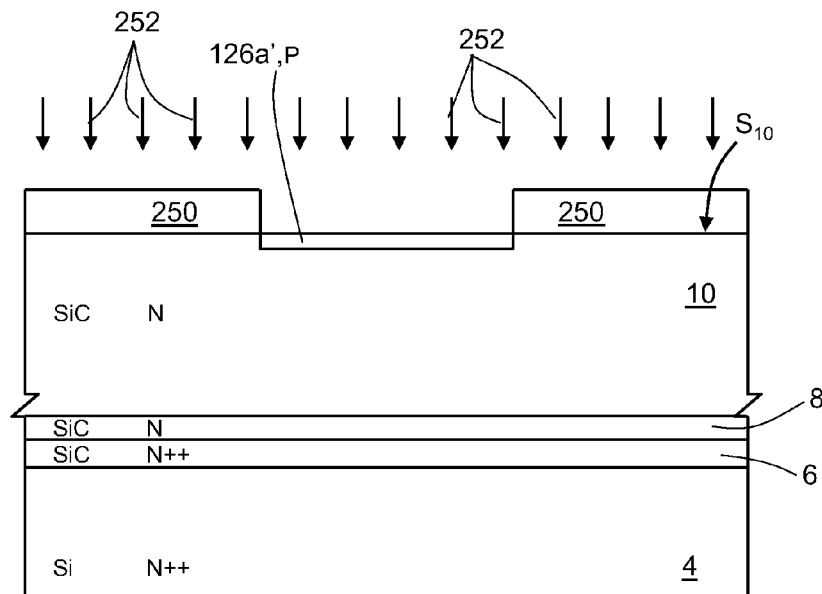


Fig.18

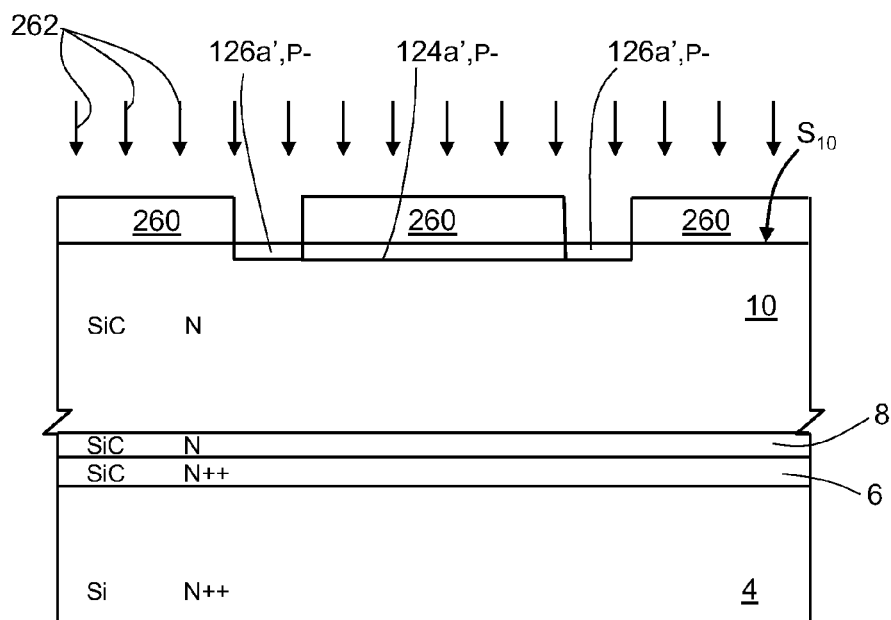


Fig.19

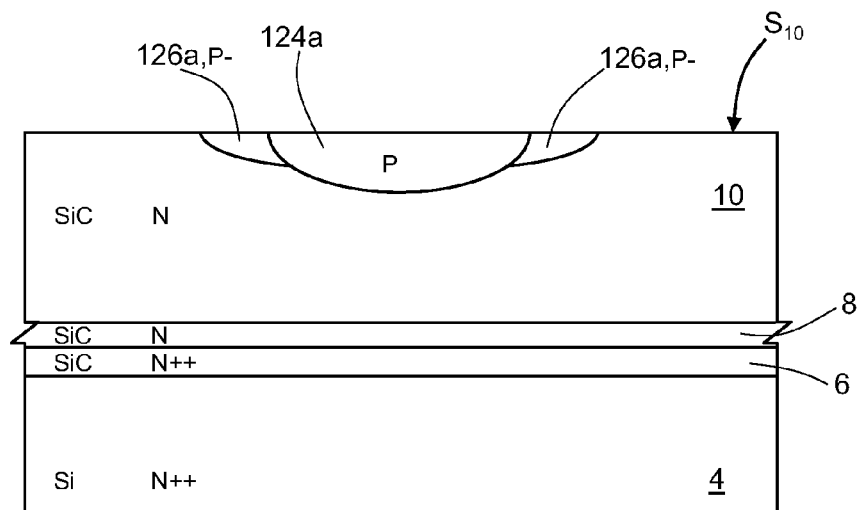


Fig.20

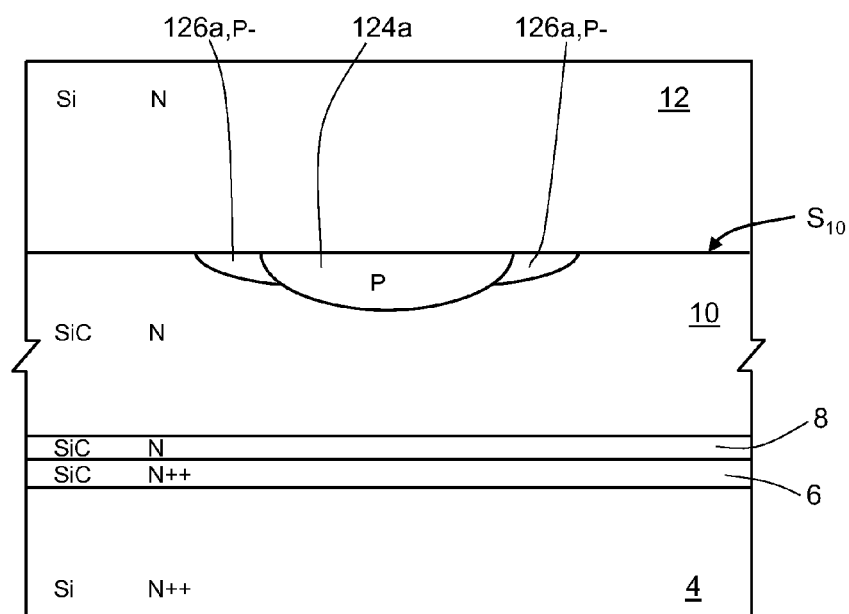


Fig.21

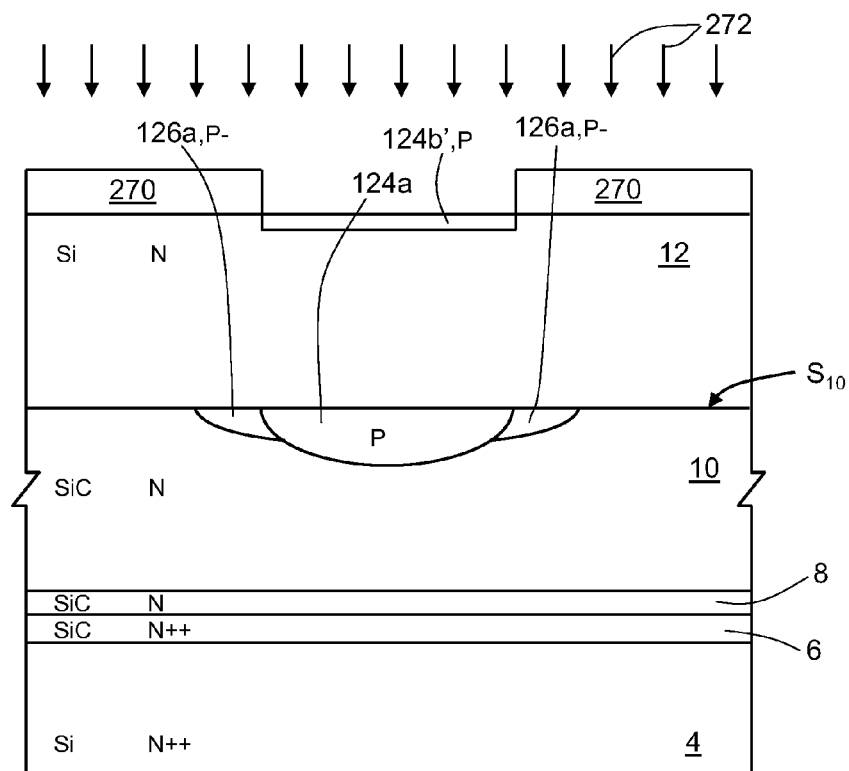


Fig.22

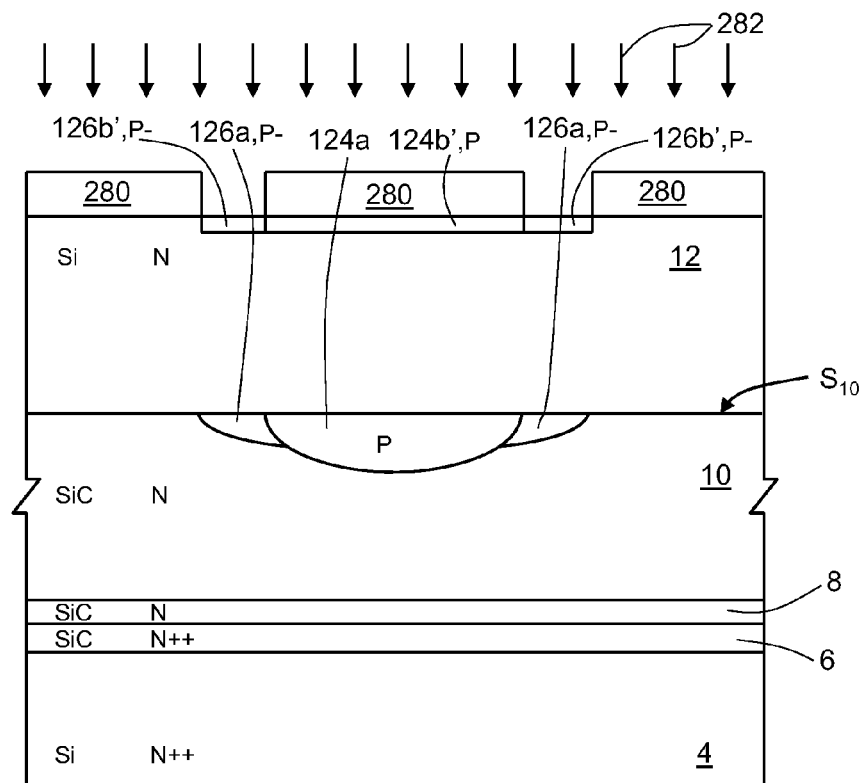


Fig.23

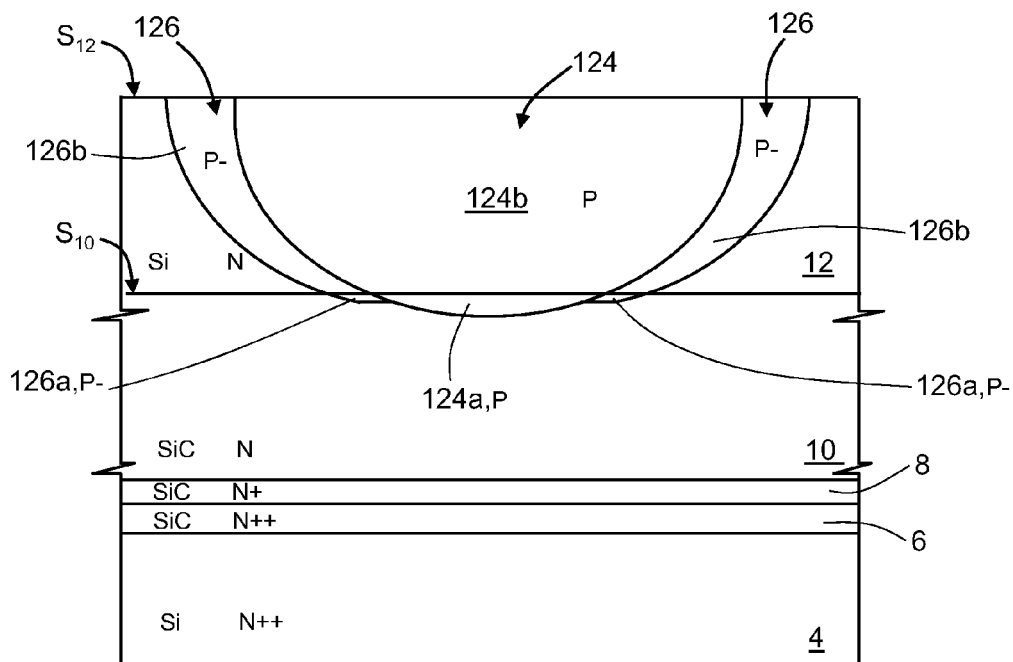


Fig.24

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INTEGRATED ELECTRONIC DEVICE AND METHOD FOR MANUFACTURING THEREOF

RELATED APPLICATION DATA

This application is related to U.S. patent application Ser. No. 13/221,694 filed Aug. 30, 2011, now U.S. Pat. No. 8,653,590 issued Feb. 18, 2014 entitled VERTICAL-CONDUCTION INTEGRATED ELECTRONIC DEVICE AND METHOD FOR MANUFACTURING THEREOF, and U.S. patent application Ser. No. 13/221,778 filed Aug. 30, 2011, now U.S. Pat. No. 9,018,635 issued Apr. 28, 2015, entitled INTEGRATED ELECTRONIC DEVICE WITH EDGE-TERMINATION STRUCTURE AND MANUFACTURING METHOD THEREOF, and which are incorporated herein by reference in their entireties.

TECHNICAL FIELD

An embodiment relates to an integrated electronic device and to the method for manufacturing thereof.

BACKGROUND

As is known, there are today available numerous electronic devices made at least in part of silicon carbide (SiC).

For example, there are today available metal-oxide semiconductor field-effect transistors (MOSFETs) made at least in part of silicon carbide, which is characterized by a bandgap that is wider than the bandgap of silicon. Consequently, given the same doping level, the critical electrical field of silicon carbide is higher than the critical electrical field of silicon. For example, in the case where silicon carbide has a so-called 3C polytype, the critical electrical field is approximately equal to four times the critical electrical field of silicon; in the cases where silicon carbide has instead a 6H or a 4H polytype, the critical electrical field is, respectively, approximately eight times and ten times the critical electrical field of silicon.

Thanks to its high critical electrical field, silicon carbide enables provision of junctions having breakdown voltages higher than what may be obtained using silicon. Furthermore, exploiting the high critical electrical field, it may be possible to provide transistors with drift regions having thicknesses smaller than the drift regions of traditional silicon transistors; said transistors are hence characterized by low on-resistances (R_{on}).

On the other hand, silicon carbide has a low diffusiveness of the dopant species, even at high temperatures. In addition, as compared to silicon, silicon carbide is characterized by a reduced mobility μ of the carriers. In fact, in silicon carbide, the mobility μ of the carriers is typically of the order of some hundreds of cm^2/Vs , whereas, in silicon, the mobility μ of the carriers can exceed even thousands of cm^2/Vs . In particular, in the case of MOSFETs made of 4H-polytype silicon carbide, the mobility μ of the carriers in the respective channel regions is limited to approximately $50 \text{ cm}^2/\text{Vs}$, on account of the generation of states at the oxide-semiconductor interfaces.

In greater detail, there are today available electronic devices formed starting from a silicon-carbide substrate. However, the technology today available does not enable provision of silicon-carbide wafers with diameters larger than four inches; consequently, the manufacture of said electronic devices is generally more costly and technologically complex than the manufacture of electronic devices starting from silicon substrates.

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In order to combine the advantages of silicon and silicon carbide, electronic devices have moreover been proposed formed starting from a silicon substrate and comprising one or more silicon-carbide epitaxial layers. For example, U.S. Pat. No. 5,877,515, which is incorporated by reference, describes a semiconductor device, and in particular a MOSFET, having a silicon layer, which is deposited on a silicon-carbide layer, which in turn is deposited on a silicon substrate.

Operatively, the silicon-carbide layer enables a concentration of charge to be obtained that is higher than what may be obtained in the case of a silicon layer, given the same breakdown voltage. However, it may be possible that in certain conditions, and in particular in the case where the semiconductor device is biased so as to work in the region of inhibition, a non-negligible electrical field is generated within the silicon substrate. In said conditions, it is the silicon itself that limits, with its own critical electrical field, the breakdown voltage of the semiconductor device.

In order to prevent generation of a non-negligible electrical field within the silicon substrate, it may be possible to increase the thickness of the silicon-carbide layer; however, said operation, in addition to being technologically complex, entails an increase of the on-resistance of the semiconductor device.

SUMMARY

An embodiment is an integrated electronic device and a manufacturing method that enable drawbacks of the known art to be overcome at least in part.

BRIEF DESCRIPTION OF THE DRAWINGS

For a better understanding of disclosed concepts, embodiments are now described, purely by way of non-limiting example and with reference to the annexed drawings, wherein:

FIGS. 1 and 3 show cross sections of embodiments of trench MOSFETs;

FIGS. 2 and 4 show cross sections of embodiments of planar-cell MOSFETs;

FIG. 5 shows a cross section of an embodiment of a trench IGBT;

FIG. 6 shows a cross section of an embodiment of a planar-cell IGBT;

FIG. 7 shows a cross section of an embodiment of a JFET;

FIG. 8 shows a cross section of an embodiment of a bipolar junction transistor; and

FIGS. 9-24 show cross sections of an embodiment of an integrated electronic device during successive manufacturing steps.

DETAILED DESCRIPTION

FIG. 1 shows an embodiment of the present integrated electronic device, which forms in the case in point a trench MOSFET 1.

In detail, the trench MOSFET 1 is formed by a body 2 of semiconductor material, which is made up of a silicon substrate 4, of an N++ type (for example, doped with arsenic) and has a bottom surface S_4 ; the silicon may have a crystallographic structure of the so-called <100> type. Furthermore, the body 2 includes a first buffer layer 6, a second buffer layer 8, and a drift layer 10.

In detail, the substrate 4 has a thickness h_4 of approximately between $500 \mu\text{m}$ and $1500 \mu\text{m}$, and moreover has a

doping level higher than approximately $1 \cdot 10^{19} \text{ cm}^{-3}$, in such a way that the resistivity ρ is lower than approximately $6 \text{ m}\Omega \cdot \text{cm}$.

The first buffer layer **6** is set on top of the substrate **4**, with which it is in direct contact, is made of silicon carbide and is of an N++ type (for example, doped with nitrogen or phosphorus). In particular, the first buffer layer **6** is made of silicon carbide of the 3C polytype, which, when grown on silicon of the <100> type, has a crystalline lattice with a low concentration of imperfections. In addition, the first buffer layer **6** has a thickness h_6 lower than approximately $0.5 \text{ }\mu\text{m}$, and moreover has a doping level of approximately between $5 \cdot 10^{16} \text{ cm}^{-3}$ and $1 \cdot 10^{17} \text{ cm}^{-3}$.

The second buffer layer **8** is arranged on top of the first buffer layer **6**, with which it is in direct contact, is made of silicon carbide and is of an N+ type (for example, doped with nitrogen or phosphorus). In particular, also the second buffer layer **8** is made of silicon carbide of the 3C polytype. In addition, the second buffer layer **8** has a thickness h_8 lower than approximately $0.5 \text{ }\mu\text{m}$, and moreover has a doping level of approximately between $1 \cdot 10^{16} \text{ cm}^{-3}$ and $5 \cdot 10^{16} \text{ cm}^{-3}$.

The drift layer **10** is arranged on top of the second buffer layer **8**, with which it is in direct contact, is made of silicon carbide, and is of an N type (for example, doped with nitrogen or phosphorus). In particular, also the drift layer **10** is made of silicon carbide of the 3C polytype. In addition, the drift layer **10** has a thickness h_{10} of approximately between $1 \text{ }\mu\text{m}$ and $10 \text{ }\mu\text{m}$, and moreover has a doping level of approximately between $1 \cdot 10^{15} \text{ cm}^{-3}$ and $1 \cdot 10^{16} \text{ cm}^{-3}$. Furthermore, the drift layer **10** defines an intermediate surface S_{10} .

The body **2** of the trench MOSFET **1** further includes a top layer **12**, which is made of silicon and is of an N type (for example, doped with phosphorus).

In detail, the top layer **12** defines a top surface S_{12} and extends over the intermediate surface S_{10} , in direct contact with the drift layer **10**. Furthermore, the top layer **12** has a thickness h_{12} in the range approximately between $1 \text{ }\mu\text{m}$ and $3 \text{ }\mu\text{m}$; again, the top layer **12** has a doping level of approximately between $1 \cdot 10^{15} \text{ cm}^{-3}$ and $1 \cdot 10^{16} \text{ cm}^{-3}$.

In practice, the body **2** of semiconductor material is delimited by the top surface S_{12} and by the bottom surface S_4 . Furthermore, extending underneath the intermediate surface S_{10} are a first semiconductor region **14a** and a second semiconductor region **14b**, both of a P+ type.

In detail, the first and second semiconductor regions **14a**, **14b** are arranged at a distance apart laterally so as to define an internal region **16**, arranged between the first and second semiconductor regions **14a**, **14b**. Furthermore, the first and second semiconductor regions **14a**, **14b** extend from the intermediate surface S_{10} , with a depth h_{14} smaller than the thickness h_{10} , for example, smaller than approximately $1 \text{ }\mu\text{m}$. Once again, the first and second semiconductor regions **14a**, **14b** have a doping peak level of approximately between $1 \cdot 10^{17} \text{ cm}^{-3}$ and $1 \cdot 10^{19} \text{ cm}^{-3}$.

Operatively, the first and second semiconductor regions **14a**, **14b** function, respectively, as first and second deep body regions **14a**, **14b**.

The trench MOSFET **1** further includes a trench **20**, which extends from the top surface S_{12} and has a thickness h_{20} . As illustrated by way of example in FIG. 1, the thickness h_{20} may be such that $h_{20} \geq h_{12}$. In other words, the trench **20** may extend through the top layer **12** until it partially penetrates within the drift layer **10**; for example, it may be possible that $h_{20} = h_{12} + \Delta$, with Δ approximately between $0.5 \text{ }\mu\text{m}$ and $1 \text{ }\mu\text{m}$. Furthermore, the trench **20** is arranged at a distance apart laterally with respect to the first and second deep body regions **14a**, **14b**, so as to extend within the internal region **16** without

contacting the first and second deep body regions **14a**, **14b**, which are approximately equidistant from the trench **20** itself.

In detail, the trench **20** is delimited by a wall **22**, and the first and second deep body regions **14a**, **14b** are both at a distance of approximately d from the wall **22**. In practice, if we designate by w_{20} the width of the trench **20** and by w_{16} the width of the internal region **16**, we have $w_{16} \approx w_{20} + 2d$.

In greater detail, the wall **22** is coated internally with a first oxide layer **24**. Furthermore, present within the trench **20** is a first gate region **26**, which is in direct contact with the first oxide layer **24** and is made of polysilicon.

The trench MOSFET **1** further includes a first oxide region **30**, which is deposited on the top surface S_{12} , is vertically aligned with the trench **20**, and is in direct contact with the first oxide layer **24** and with the first gate region **26**. The first oxide region may have a thickness, for example, approximately between 20 nm and 80 nm .

The trench MOSFET **1** further includes a first top body region **32a** and a second top body region **32b**, both of a P type (for example, doped with boron) and with a peak doping level of approximately between $1 \cdot 10^{16} \text{ cm}^{-3}$ and $1 \cdot 10^{18} \text{ cm}^{-3}$. In detail, the first and second top body regions **32a**, **32b** are arranged laterally at a distance apart and extend through the top layer **12** starting from the top surface S_{12} , until they contact, respectively, the first and second deep body regions **14a**, **14b**. Furthermore, the first and second top body regions **32a**, **32b** extend laterally until they contact the wall **22** of the trench **20**, which separates the first and second top body regions **32a**, **32b**.

The trench MOSFET **1** further includes a first source region **34** formed by a first source subregion **34a** and a second source subregion **34b**, both of an N+ type (for example, doped with phosphorus) and with a peak doping level of approximately $1 \cdot 10^{20} \text{ cm}^{-3}$. In detail, the first and second source subregions **34a**, **34b** extend, starting from the top surface S_{12} , within the top layer **12**. In greater detail, the first and second source subregions **34a**, **34b** are arranged laterally at a distance apart, in such a way that the trench **20** extends between the first and second source subregions **34a**, **34b**, with which it is in direct contact. In particular, the first and second source subregions **34a**, **34b** are in direct contact with the first oxide layer **24**; moreover, the first and second source subregions **34a**, **34b** are in direct contact with the first oxide region **30**.

In practice, the first source region **34** and the trench **20** are housed within a operative region **O**, a bottom portion of which is formed by the internal region **16** and is hence delimited by the first and second deep body regions **14a**, **14b**.

The trench MOSFET **1** further includes a first dielectric region **35**, which overlies, in direct contact, the first oxide region **30**, and is in direct contact with the first and second source subregions **34a**, **34b**.

The trench MOSFET **1** further includes a first top metallization **36** and a bottom metallization **38**, as well as a first gate metallization, the latter (not shown) contacting, in a way in itself known, the first gate region **26**.

In detail, the first top metallization **36** extends over the top surface S_{12} , surrounding at the top and laterally the first dielectric region **35**, and contacting the first and second source subregions **34a**, **34b**, as well as the first and second top body regions **32a**, **32b**.

The bottom metallization **38** extends, instead, underneath the bottom surface S_4 of the substrate **4**, with which it is in direct contact. In practice, the substrate **4**, the first and second buffer layers **6**, **8**, and the drift layer **10** function as a drain region.

Operatively, the first top metallization **36** functions as a source metallization, whilst the bottom metallization **38** func-

tions as a drain metallization. Furthermore, the first gate region **26**, the first oxide layer **24**, and the top layer **12** (and in particular, the first and second top body regions **32a**, **32b**) form a junction of the metal-oxide-semiconductor type. Hence, by biasing in a way in itself known the first top metallization **36** and the first gate metallization, it is possible to form a channel of an N type within the top layer **12**, in particular within a region of the top layer **12** arranged in direct contact with the first oxide layer **24**. Furthermore, by biasing in a way in itself known the first top metallization **36** and the bottom metallization **38** with a voltage V_{DS} , it is possible to generate a current I_{DS} .

The current I_{DS} flows between the first top metallization **36** and the bottom metallization **38**; hence, it has a vertical direction and flows both through the silicon and through the silicon carbide. In particular, the current I_{DS} flows within the channel of an N type, traversing the top layer **12**, as well as the drift layer **10** and the first and second buffer layers **6**, **8**.

In the case where the voltage V_{DS} is such as to reversely bias the PN junctions present between the drift layer **10** and the first and second deep body regions **14a**, **14b**, the magnitude of the voltage V_{DS} cannot exceed a maximum voltage V_{max} ; otherwise, a breakdown phenomenon within the trench MOSFET **1** would be triggered.

In particular, the maximum voltage V_{max} is particularly high thanks to the presence of the first and second buffer layers **6**, **8**, and to the respective doping levels, which prevent the generation of significant electrical fields within the silicon substrate **4**.

Likewise, the first and second deep body regions **14a**, **14b** prevent generation of significant electrical fields within the top silicon layer **12**. In other words, the voltage V_{DS} drops substantially within the first and second deep body regions **14a**, **14b**, as well as within the drift layer **10** and the first and second buffer layers **6**, **8**. Instead, within the top layer **12** and the substrate **4**, there is little to no voltage drop, because the electrical field is, to a first approximation, negligible. Consequently, the maximum voltage V_{max} is limited at the top, instead of by the critical electrical field of silicon, by the critical electrical field of silicon carbide, which, as has been said, is higher than the critical electrical field of silicon.

Furthermore, with regard to the top layer **12**, the electrical field present therein is negligible not only in the proximity of the first and second deep body regions **14a**, **14b**, but also in the proximity of the internal region **16**, i.e., where the top layer **12** is not in direct contact with the first and second deep body regions **14a**, **14b**. In fact, as illustrated qualitatively in FIG. 1, underneath the first and second deep body regions **14a**, **14b**, the equipotential lines L that are generated in use within the trench MOSFET **1** are approximately parallel to the first and second deep body regions **14a**, **14b**. Instead, in an area corresponding to the internal region **16**, the equipotential lines L bend on account of the presence of the trench **20**, and in particular of the first oxide layer **24**.

FIG. 2 illustrates a different embodiment of the present integrated electronic device, which in the case in point forms a planar-cell MOSFET **50**, described in what follows. Elements already present in the trench MOSFET **1** illustrated in FIG. 1 are designated by the same reference numbers; moreover, the ensuing description is limited to the differences of the planar-cell MOSFET **50** with respect to the trench MOSFET **1** illustrated in FIG. 1.

In detail, the planar-cell MOSFET **50** is without the trench **20**, and consequently also without the first oxide layer **24** and the first gate region **26**. Furthermore, arranged between the first oxide region **30** and the first dielectric region **35** is a second gate region **52**, made of polysilicon, which overlies

the first oxide region **30**, with which it is in direct contact. In particular, the second gate region **52** has a thickness equal, for example, to approximately 600 nm.

In addition, the first and second top body regions **32a**, **32b** surround laterally, respectively, the first and second source subregions **34a**, **34b**. Furthermore, in a way similar to what is illustrated in FIG. 1, also the planar-cell MOSFET **50** includes the first top metallization **36**, the bottom metallization **38**, and the first gate metallization, the latter (not shown) contacting in a way in itself known the second gate region **52**.

Operatively, the second gate region **52**, the first oxide region **30**, and the top layer **12** form a junction of the metal-oxide-semiconductor type; consequently, by biasing in a way in itself known the first source region **34** and the second gate region **52**, it may be possible to form, underneath the first oxide region **30**, a channel of an N type. In particular, the channel of an N type extends within portions of the first and of the second top body regions **32a**, **32b** in contact with the first oxide region **30** and between the first and second source subregions **34a**, **34b**.

Furthermore, by biasing in a way in itself known the first top metallization **36** and the bottom metallization **38** with the voltage V_{DS} , it may be possible to generate the current I_{DS} , which flows vertically, traversing the internal region **16**, in a way similar to what has been described previously.

FIG. 3 illustrates a different embodiment of the present integrated electronic device, which in the case in point forms an enhanced trench MOSFET **60**, described in what follows. Elements already present in the trench MOSFET **1** illustrated in FIG. 1 are designated by the same reference numbers; moreover, the ensuing description is limited to the differences of the enhanced trench MOSFET **60** with respect to the trench MOSFET **1** illustrated in FIG. 1.

In detail, the enhanced trench MOSFET **60** includes one or more intermediate layers of an N type (for example, doped with nitrogen or phosphorus), which are arranged between the drift layer **10** and the top layer **12**, and are made of silicon carbide of the 3C polytype. Furthermore, the intermediate layers may have approximately one and the same thickness h_{62} and one and the same doping level, for example equal to the doping level of the drift layer **10**.

By way of example, the embodiment illustrated in FIG. 3 has a first intermediate layer and a second intermediate layer, designated by **62a** and **62b**, respectively. In particular, the first intermediate layer **62a** overlies the drift layer **10**, with which it is in direct contact. Instead, the second intermediate layer **62b** overlies the first intermediate layer **62a**, with which it is in direct contact, and is overlaid by the top layer **12**, with which it is in direct contact. The second intermediate layer **62b** defines moreover a contact surface S_{62} , which contacts the top layer **12**. In addition, in said embodiment, the trench **20** may extend, for example, up to the contact surface S_{62} , i.e., with $h_{20}=h_{10}$ (or approximately equal to h_{10}).

The enhanced trench MOSFET **60** further includes a first intermediate body region **64** and a second intermediate body region **66**, both of a P type (for example, doped with boron) and with peak doping levels of approximately between $1 \cdot 10^{16} \text{ cm}^{-3}$ and $1 \cdot 10^{18} \text{ cm}^{-3}$. In detail, the first and second intermediate body regions **64**, **66** are arranged laterally at a distance apart and extend through the first and second intermediate layers **62a**, **62b**, starting from the contact surface S_{62} , until they contact, respectively, the first and second deep body regions **14a**, **14b**. Furthermore, the first and second intermediate body regions **64**, **66** are, respectively, in contact with the first and second top body regions **32a**, **32b**.

Operatively, defining as a confinement region **68** the region formed by the portions of the first and second intermediate

layers **62a**, **62b** not occupied either by the first intermediate body region **64** or by the second intermediate body region **66**, it is possible to verify that, in use, the electrical field assumes, in this confinement region **68**, a direction to a first approximation horizontal, i.e., parallel to the intermediate surface S_{10} . In this way, the possibility of formation within the top layer **12** of an appreciable electrical field is further reduced.

As illustrated in FIG. 4, a different embodiment of the present integrated electronic device is possible, which forms a modified planar-cell MOSFET **70**, which in what follows will be referred to as “enhanced planar-cell MOSFET **70**”, described in what follows. Elements already present in the planar-cell MOSFET **50** illustrated in FIG. 2 are designated by the same reference numbers.

In detail, with respect to the planar-cell MOSFET **50**, the enhanced planar-cell MOSFET **70** includes the already described one or more intermediate layers, as well as the first and second intermediate body regions **64**, **66**. In particular, the embodiment illustrated in FIG. 4 has the already mentioned first and second intermediate layers **62a**, **62b**, which enable the aforementioned reduction of the electrical field to be obtained within the top layer **12**.

According to further embodiments of the present integrated electronic device, it may form, moreover, an insulated-gate bipolar junction transistor (IGBT), and in particular a trench IGBT **80** (FIG. 5), or else a planar-cell IGBT **90** (FIG. 6).

As illustrated in FIG. 5, where elements already illustrated in FIG. 1 are designated by the same reference numbers, the trench IGBT **80** differs from the trench MOSFET **1** in that it is formed starting from an alternative substrate **4b**, instead of from the substrate **4** described previously.

In particular, the alternative substrate **4b** is made of silicon with crystallographic structure of the $\langle 100 \rangle$ type, and is of a P++ type (for example, doped with boron); moreover, the alternative substrate **4b** has a thickness h_{4b} of approximately between 500 μm and 1500 μm , and has a doping level higher than approximately $1 \cdot 10^{19} \text{ cm}^{-3}$, in such a way that the resistivity ρ is lower than approximately 6 $\text{m}\Omega \cdot \text{cm}$.

Operatively, the first and second deep body regions **14a**, **14b** function, together with the first and the second top body regions **32a**, **32b**, as a collector of an additional bipolar junction transistor of the PNP type, the base of which is formed by the first and second buffer layers **6**, **8** and by the drift layer **10**, and the emitter of which is formed by the alternative substrate **4b**.

Likewise, as illustrated in FIG. 6, where elements already illustrated in FIG. 2 are designated by the same reference numbers, the planar-cell IGBT **90** differs from the planar-cell MOSFET **50** in that it is formed starting from the alternative substrate **4b**, instead of from the substrate **4**.

According to yet a further embodiment, the present integrated electronic device may moreover form a junction field-effect transistor **100** (JFET), illustrated in FIG. 7, where elements already illustrated in FIG. 1 are designated by the same reference numbers.

In detail, the JFET **100** includes the substrate **4**, the first and second buffer layers **6**, **8**, and the drift layer **10**, as well as the first and second semiconductor regions **14a**, **14b**, which function, respectively, as first and second gate subregions **14a**, **14b**. Instead, the JFET **100** is without the top layer **12**.

The JFET **100** further includes a second source region **102**, made of silicon and of an N++ type (for example doped with phosphorus). In particular, the second source region **102** extends over the intermediate surface S_{10} , in direct contact

with the internal region **16**, and has a doping level approximately equal to $1 \cdot 10^{19} \text{ cm}^{-3}$ and a thickness h_{102} lower than approximately 2 μm .

The JFET **100** further includes, instead of the first top metallization **36**, a second top metallization **104**, which overlies the second source region **102**, with which it is in direct contact, and performs the function of source metallization. Furthermore, the JFET **100** includes a second dielectric region **106** (formed, for example, of borophosphosilicate glass, BPSG), which extends over the intermediate surface S_{10} and surrounds laterally the second source region **102** and the second top metallization **104**, with which it is in direct contact. Once again, in addition to the bottom metallization **38**, the JFET **100** includes a second gate metallization **108**, which extends over the intermediate surface S_{10} and surrounds the second dielectric region **106**, with which it is in direct contact. Furthermore, the second gate metallization **108** contacts the first and second gate subregions **14a**, **14b**.

In use, in the absence of voltage between the second top metallization **104** and the second gate metallization **108**, at the interface between the drift layer **10** and the first gate subregion **14a** a first depleted region D_a is formed, and at the interface between the drift layer **10** and the second body subregion **14b** a second depleted region D_b is formed. These first and second depleted regions D_a , D_b extend within the drift layer **10** with a depth of approximately w_{db} . Furthermore, in this embodiment, the width w_{16} of the internal region **16**, i.e., the lateral distance between the first and second gate subregions **14a**, **14b**, and the doping levels of the drift layer **10** and the first and the second gate subregions **14a**, **14b** are such that $w_{db} \approx w_{16}/2$. In other words, in the absence of voltage between the second top metallization **104** and the second gate metallization **108**, the first and second depleted regions D_a , D_b contact one another, insulating the second source region **102** from the substrate **4** and from the first and second buffer layers **6**, **8**, which function as drain regions. Consequently, the JFET **100** is a vertical-current-conduction device of the normally off type.

According to a further embodiment, the present integrated electronic device may form a bipolar junction transistor **120**, illustrated in FIG. 8, where elements already illustrated in FIG. 1 are designated by the same reference numbers.

In detail, the bipolar junction transistor **120** includes the substrate **4**, the first and second buffer layers **6**, **8**, the drift layer **10**, and the top layer **12** described previously. Furthermore, the bipolar junction transistor **120** includes an emitter region **122**, of an N+ type (for example, doped with phosphorus), which extends, starting from the top surface S_{12} , within the top layer **12**, with a doping level approximately equal to $1 \cdot 10^{20} \text{ cm}^{-3}$.

In addition, the bipolar junction transistor **120** includes, instead of the first and second semiconductor regions **14a**, **14b**, a base region **124** of a P type (for example, doped with boron), and moreover includes an edge region **126** of a P-type (for example, doped with boron).

In detail, the base region **124** has a peak doping level of approximately between $1 \cdot 10^{16} \text{ cm}^{-3}$ and $1 \cdot 10^{18} \text{ cm}^{-3}$; moreover, the base region **124** faces the top surface S_{12} and extends within the top layer **12** so as to surround laterally and at the bottom the emitter region **122**, to which it is vertically aligned. In particular, the base region **124** traverses the entire top layer **12** and extends partially within the drift layer **10**, underneath the intermediate surface S_{10} .

The edge region **126** has a peak doping level of approximately between $1 \cdot 10^{14} \text{ cm}^{-3}$ and $1 \cdot 10^{16} \text{ cm}^{-3}$; moreover, the edge region **126** faces the top surface S_{12} and extends within the top layer **12**, externally with respect to the base region

124, with which it is in direct contact. In particular, the edge region **126** traverses the entire top layer **12** and extends partially within the drift layer **10**, underneath the intermediate surface S_{10} , laterally surrounding the base region **124**.

The bipolar junction transistor **120** further includes a channel-stopper region **128** of an N+ type (for example, doped with phosphorus) and with a doping level approximately equal to $1 \cdot 10^{20} \text{ cm}^{-3}$, which extends in the top layer **12**, externally and at a distance from the edge region **126**.

The bipolar junction transistor **120** further includes an emitter metallization **130**, a base metallization **132**, and an equipotential ring **134** (EQR), made of metal material, in addition to the bottom metallization **38**, which functions as collector metallization and is coupled, in a way in itself known, to the equipotential ring **134**.

In detail, the emitter metallization **130**, the base metallization **132**, and the equipotential ring **134** extend over the top surface S_{12} and are in direct contact, respectively, with the emitter region **122**, the base region **124**, and the channel-stopper region **128**.

The bipolar junction transistor **120** finally includes an insulating region **140**, made of dielectric material, deposited on the top surface S_{12} , with which it is in direct contact, but for the contacts between the emitter metallization **130**, the base metallization **132**, the equipotential ring **134**, and, respectively, the emitter region **122**, the base region **124** and the channel-stopper region **128**.

In use, the drift layer **10**, part of the top layer **12**, and the first and second buffer layers **6**, **8** function as collector region of the bipolar junction transistor **120**. Furthermore, the edge region **126** prevents concentration of the equipotential lines, and hence generation of a high electrical field, in the proximity of the PN junctions, which would be formed, in the absence of said edge region **126**, between the base region **124** and the top layer **12** and the drift layer **10**. In this way, a reduction of the maximum voltage V_{max} at which the bipolar junction transistor **120** can operate without incurring in the breakdown phenomenon is avoided. As explained previously, also in the case of the bipolar junction transistor **120**, said maximum voltage V_{max} depends to a first approximation upon the critical electrical field of silicon carbide, thanks to the fact that the base region **124** extends also underneath the intermediate surface S_{10} .

As regards, instead, the channel-stopper region **128**, it performs, in a way in itself known, the function of preventing formation of channels between the base region **124** and the outermost portions of the bipolar junction transistor **120**.

An embodiment of the present electronic device may be obtained using the manufacturing method described in what follows and represented in FIGS. 9-24. In particular, the ensuing description regards, without this implying any loss of generality, manufacture of the trench MOSFET **1**, of the enhanced trench MOSFET **60**, of the JFET **100**, and of the bipolar junction transistor **120**; however, an embodiment of the manufacturing technique may be used to manufacture the devices **50**, **70**, **80**, and **90** as well.

As illustrated in FIG. 9, to obtain the trench MOSFET **1** the substrate **4** is provided, and subsequently the first buffer layer **6**, the second buffer layer **8**, and the drift layer **10** are formed by epitaxial growth.

Next (FIG. 10), using a first resist mask **200**, a first implantation of dopant species of a P type (for example, aluminium or boron atoms) is performed, represented by the arrows **202**, so as to localize the dopant species in a first thin layer **14a'** and a second thin layer **14b'**, both of a P+ type, which are arranged underneath the intermediate surface S_{10} and are to form, respectively, the first and second deep body regions **14a**, **14b**,

once appropriate annealing processes are terminated, as explained hereinafter. In particular, the first implant is executed with a hot process, i.e., at a temperature of approximately between 500° C. and 850° C. , in order to limit the defects introduced during the implant itself within the silicon-carbide crystalline lattice; moreover, the first implant may be made with a dosage in a range approximately between $1 \cdot 10^{13} \text{ cm}^{-2}$ and $1 \cdot 10^{15} \text{ cm}^{-2}$ and an energy in the range approximately between 30 keV and 2 MeV. Furthermore, in a way in itself known, and hence not illustrated, the first implant may be made after providing, on the intermediate surface S_{10} , a temporary silicon layer, which is removed at the end of the first implant; in this way, the lattice defects introduced during the first implant within the silicon-carbide crystalline lattice are further limited.

Next (FIG. 11), the first resist mask **200** is removed, and an annealing at a temperature of approximately between 1250° C. and 1365° C. , and of the duration, for example, of approximately thirty minutes, is performed in order to reduce the sites of the drift layer **10** damaged following upon the first implant, and activate the dopant species. During said annealing, the thickness of the first and second thin layers **14a'**, **14b'** increases, and the first and second thin layers **14a'**, **14b'** form, respectively, the first and second deep body regions **14a**, **14b**.

Next (FIG. 12), the top layer **12**, made of silicon, is formed, by means of hetero-epitaxy.

In a way in itself known, and consequently not illustrated, by means of chemical etching, the trench **20** is formed, and subsequently formed in succession, once again in a way in itself known, are the first oxide layer **24**, the first gate region **26**, the first and second top body regions **32a**, **32b**, and the source region **34**.

Then formed, in a way in itself known, are the first oxide region **30** and the first dielectric region **35**, and finally the first top metallization **36** and the bottom metallization **38**.

As regards the enhanced trench MOSFET **60**, to produce one may perform the operations described in what follows, which refer, by way of example, to the embodiment illustrated in FIG. 3.

In detail, the operations illustrated in FIGS. 9-10 are performed. Next (FIG. 13), hence after performing the first implant, the first resist mask **200** is removed and, by means of epitaxial growth, the first intermediate layer **62a** is formed.

Next, by means of a second resist mask **210**, a second implant of dopant species of a P type (for example, aluminium or boron atoms) is performed, represented by the arrows **212**, so as to localize the dopant species in a third thin layer **64'** and a fourth thin layer **66'**, both of a P+ type. In particular, if one designates by S_{62a} the top surface of the first intermediate layer **62a**, the third and the fourth thin layers **64'** and **66'** are arranged underneath the surface S_{62a} of the first intermediate layer **62a**, and are to form, respectively, the first and second intermediate body regions **64**, **66**, once appropriate annealing processes are terminated. Also this second implant is executed with a hot process, i.e., at a temperature of approximately between 500° C. and 850° C. , and with a dosage comprised in the range approximately between $1 \cdot 10^{13} \text{ cm}^{-2}$ and $1 \cdot 10^{15} \text{ cm}^{-2}$ and an energy approximately between 30 keV and 2 MeV. Furthermore, in a way in itself known, and hence not illustrated, also the second implant may be made after providing, on the surface S_{62a} of the first intermediate layer **62a**, a temporary silicon layer, which is removed at the end of the second implant.

Next (FIG. 14), the second resist mask **210** is removed and, by means of epitaxial growth, the second intermediate layer **62b** is formed, and subsequently, by means of a third resist mask **220**, a third implant of dopant species of a P type (for

example, aluminium or boron atoms) is performed, represented by the arrows **222**, so as to localize the dopant species in a fifth thin layer **64''** and a sixth thin layer **66''**, both of a P+ type. In particular, the fifth and sixth thin layers **64''** and **66''** are arranged underneath the contact surface S_{62} and are to form, respectively, the first and second intermediate body regions **64**, **66**, once appropriate annealing processes are terminated. Also this third implant is executed with a hot process, i.e., at a temperature of approximately between 500° C. and 850° C., and with a dosage in the range approximately between $1 \cdot 10^{13} \text{ cm}^{-3}$ and $1 \cdot 10^{15} \text{ cm}^{-3}$ and an energy approximately between 30 keV and 2 MeV. Furthermore, in a way in itself known, and hence not illustrated, also the third implant may be made after providing, on the contact surface S_{62} , a temporary silicon layer, which is removed at the end of the third implant.

Next (FIG. 15), the third resist mask **220** is removed, and an annealing at a temperature of approximately between 1250° C. and 1365° C., and of the duration, for example, of thirty minutes is performed. In this way, the first and second thin layers **14a'**, **14b'** form, respectively, the first and second deep body regions **14a**, **14b**. Likewise, the third and fifth thin layers **64'**, **64''** increase in thickness and form the first intermediate body region **64**; moreover, the fourth and sixth thin layers **66'**, **66''** increase in thickness and form the second intermediate body region **66**.

It may be noted that, even though FIGS. 13 and 14 show an embodiment in which the third and fourth thin layers **64'** and **66'** have a thickness h_7 lower than the thickness h_{62} of the first intermediate layer **62a**, and in which the fifth and sixth thin layer **64''** and **66''** have a thickness h_7 lower than the thickness h_{62} of the second intermediate layer **62b**, it may be likewise possible to carry out the second and third implants in such a way that $h_7 \geq h_{62}$ and $h_7 \geq h_{62}$.

Next, the top silicon layer **12** is formed, by means of hetero-epitaxy, and then, in a way in itself known, the first and second top body regions **32a**, **32b**, the trench **20**, the first gate region **26**, the first oxide layer **24**, the first source region **34**, the first oxide region **30**, the first dielectric region **35**, as well as the first top metallization **36**, the bottom metallization **38**, and the first gate metallization are provided.

To manufacture the JFET **100** it is, instead, possible to carry out the operations illustrated in FIGS. 9-11.

Next (FIG. 16), hence, after performing the annealing, an additional layer **232**, which is made of silicon and is of an N++ type (for example, doped with phosphorus), and which is to form the second source region **102**, is formed, by means of hetero-epitaxy.

Next (FIG. 17), by means of a chemical etch, portions of the additional layer **232** are selectively removed so as to form the second source region **102**. Next, an insulating layer **236** is deposited, which is made, for example, of borophosphosilicate glass and is to form the second dielectric region **106**.

In a way not illustrated, by means of chemical etching, portions of the insulating layer **236** are selectively removed so as to form the second dielectric region **106**, and the second top metallization **104** and the second gate metallization **108** are provided.

Finally, to manufacture the bipolar junction transistor **120**, it is possible to proceed as described in what follows.

In detail, the operations illustrated in FIG. 9 are performed. Next (FIG. 18) by means of a fourth resist mask **250**, a fourth implant of dopant species of a P type (for example, aluminium or boron atoms) is performed, represented by the arrows **252**, so as to localize the dopant species in a seventh thin layer **126a'** of a P type, which is localized underneath the intermediate surface S_{10} and is to form the base region **124**.

Also this fourth implant is executed with a hot process, i.e., at a temperature of approximately between 500° C. and 850° C., and with a dosage in the range approximately between $1 \cdot 10^{14} \text{ cm}^{-2}$ and $1 \cdot 10^{15} \text{ cm}^{-2}$ and an energy approximately between 30 keV and 2 MeV. Once again, also the fourth implant may be made after providing, on the intermediate surface S_{10} , a temporary silicon layer, which is removed at the end of the fourth implant.

Next (FIG. 19) the fourth resist mask **250** is removed, and by means of a fifth resist mask **260**, a fifth implant of dopant species of a P type (for example, aluminium or boron atoms) is performed, represented by the arrows **262**, so as to localize the dopant species in an eighth thin layer **126a'** of a P- type, which is localized underneath the intermediate surface S_{10} and is to form the edge region **126**. Also this fifth implant is executed with a hot process, i.e., at a temperature of approximately between 500° C. and 850° C., and with a dosage in the range approximately between $1 \cdot 10^{12} \text{ cm}^{-2}$ and $1 \cdot 10^{13} \text{ cm}^{-2}$ and an energy approximately between 30 keV and 2 MeV. Once again, also the fifth implant may be carried out after providing, on the intermediate surface S_{10} , a temporary silicon layer, which is removed at the end of the fifth implant.

Next (FIG. 20) the fifth resist mask **260** is removed, and an annealing, at a temperature of approximately between 1250° C. and 1365° C., and of the duration, for example, of approximately thirty minutes is performed. In this way, the seventh and eighth thin layers **124a'**, **126a'** form, respectively, a first portion of base region **124a** and a first portion of edge region **126a**, which extend facing the intermediate surface S_{10} , the first portion of edge region **126a** surrounding the first portion of base region **124a**.

Next (FIG. 21), by means of epitaxial growth, the top layer **12** is formed, arranged above the intermediate surface S_{10} .

Next (FIG. 22), by means of a sixth resist mask **270**, a sixth implant of dopant species of a P type (for example, aluminium or boron atoms) is performed, represented by the arrows **272**, so as to localize the dopant species in a ninth thin layer **124b'** of a P type, which is localized underneath the top surface S_{12} and is to form the base region **124**.

Next (FIG. 23), the sixth resist mask **270** is removed and, by means of a seventh resist mask **280**, a seventh implant of dopant species of a P type (for example, aluminium or boron atoms) is performed, represented by the arrows **282**, so as to localize the dopant species in a tenth thin layer **126b'** of a P-type, localized underneath the top surface S_{12} , which surrounds the ninth thin layer **124b'** and is to form the edge region **126**.

Next (FIG. 24), the seventh resist mask **280** is removed and an annealing at a temperature of approximately between 1100° C. and 1150° C., and of the duration of approximately one hundred and twenty minutes is performed, in such a way that the ninth and tenth thin layers **124b'**, **126b'** form, respectively, a second portion of base region **124b** and a second portion of edge region **126b**, extending facing the top surface S_{12} , the second portion of edge region **126b** surrounding the second portion of base region **124b**. Furthermore, the second portion of base region **124b** and the second portion of edge region **126b** traverse the entire thickness of the top layer **12**, until they connect, respectively, to the first portion of base region **124a** and to the first portion of edge region **126a** so as to form the base region **124** and the edge region **126**.

In a way in itself known, and consequently not illustrated, the emitter region **122**, the channel-stopper region **128**, the insulating region **140**, the emitter metallization **130**, the base metallization **132**, the equipotential ring **134**, and the bottom metallization **38** are then provided.

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Advantages that embodiments of the present integrated electronic device and the present manufacturing method afford emerge clearly from the foregoing discussion.

In detail, an embodiment of the present electronic device is formed starting from a silicon substrate, with consequent benefits in terms of reduced costs and availability of wafers of large dimensions. In addition, the present integrated electronic device uses the properties of silicon carbide (wide bandgap) to confine the electrical field within the silicon-carbide epitaxial layers, preventing generation of the breakdown phenomenon within the silicon substrate. In particular, the use of the first and second buffer layers **6**, **8** prevent occurrence of breakdown within the substrate **4**. In addition, the doping profiles and the thicknesses h_6 , h_8 of the first and second buffer layers **6**, **8** may be modulated so that the electrical field that is generated therein has a desired profile.

Furthermore, according to an embodiment of the present manufacturing method, the first and second deep body regions **14a**, **14b**, as well as, in the case of the bipolar junction transistor **120**, the first portion of base region **124a**, are obtained by ion implantation, with consequent greater control of the corresponding thicknesses, which may be larger than what may be obtained by diffusion.

Finally, it is evident that modifications and variations may be made to the present integrated electronic device and manufacturing method, without thereby departing from the scope of the present disclosure.

For example, it may be possible for there to be present just one of the first buffer layer **6** and the second buffer layer **8**. In addition, it may be possible to reverse all the conductivity types of the semiconductor elements described, and/or use different semiconductor materials.

Furthermore, an embodiment of the present electronic device may be disposed on a first integrated circuit, which may be coupled to one or more second integrated circuits to form a system. One or more of the first and second integrated circuits may include a controller such as a processor.

From the foregoing it will be appreciated that, although specific embodiments have been described herein for purposes of illustration, various modifications may be made without deviating from the spirit and scope of the disclosure. Furthermore, where an alternative is disclosed for a particular embodiment, this alternative may also apply to other embodiments even if not specifically stated.

The invention claimed is:

1. A method for making a semiconductor device comprising:

providing a first semiconductor layer having a first bandgap;

forming a second semiconductor layer over the first semiconductor layer and having a second bandgap that is wider than the first bandgap, the second semiconductor layer comprising in stacked relation a first buffer semiconductor layer having a first thickness, a second buffer semiconductor layer having the first thickness, and a drift semiconductor layer having a second thickness;

forming a third semiconductor layer over the second semiconductor layer and having the first bandgap;

forming a trench in the third semiconductor layer defining first and second opposing walls;

forming a P+ type first semiconductor region spaced from the first wall and extending from a bottom surface of the third semiconductor layer into the second semiconductor layer a first depth; and

forming a P+ type second semiconductor region spaced from the second wall and extending from the bottom

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surface of the third semiconductor layer into the second semiconductor layer the first depth.

2. The method of claim **1** wherein providing the first semiconductor layer comprising providing a first substrate.

3. The method of claim **1** wherein forming the second semiconductor layer comprises forming a second epitaxial layer.

4. The method of claim **1** wherein forming the third semiconductor layer comprises forming a third epitaxial layer.

5. The method of claim **1** wherein the first semiconductor layer comprises silicon.

6. The method of claim **1** wherein the second semiconductor layer comprises silicon carbide.

7. The method of claim **1** wherein the third semiconductor layer comprises silicon.

8. The method of claim **1** wherein:

the first semiconductor layer comprises a region of a first conductivity;

the second semiconductor layer comprises a region of the first conductivity; and

the third semiconductor layer comprises a region of the first conductivity.

9. The method of claim **1** wherein:

the first semiconductor layer comprises a region of a first conductivity;

the second semiconductor layer comprises a region of a second conductivity; and

the third semiconductor layer comprises a region of the second conductivity.

10. The method of claim **1** wherein:

the first semiconductor layer comprises a region having a first doping level;

the second semiconductor layer comprises a region having a second doping level that is less than the first doping level; and

the third semiconductor layer comprises a region having a third doping level that is less than the first doping level.

11. The method of claim **1** wherein:

the first semiconductor layer comprises a region having a first doping level;

the second semiconductor layer comprises a region having a second doping level that is less than the first doping level; and

the third semiconductor layer comprises a region having a third doping level that is greater than the second doping level.

12. The method of claim **1**, wherein

the first buffer semiconductor layer is between the first and second semiconductor layers, has the second bandgap, and has a first doping level; and

the second buffer semiconductor layer is between the first and second semiconductor layers, has approximately the second bandgap, and has a second doping level that is greater than the first doping level.

13. The method of claim **1**, further comprising:

forming a trench in the second and third semiconductor layers and having a wall;

forming a gate insulator on the trench wall;

forming a gate in the trench over the gate insulator;

forming a body region of a first conductivity in the third semiconductor layer adjacent the trench;

forming a source region of a second conductivity in the body region adjacent the trench; and

forming a deep body region of the first conductivity in the second semiconductor layer adjacent the body region; and

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wherein the first semiconductor layer has the second conductivity.

14. The method of claim 1, further comprising:

forming a trench in the second and third semiconductor layers and having a wall;

forming a gate insulator on the trench wall;

forming a gate in the trench over the gate insulator;

forming a body region of a first conductivity in the third semiconductor layer adjacent the trench;

forming a source region of a second conductivity in the body region adjacent the trench; and

forming a deep body region of the first conductivity in the second semiconductor layer adjacent the body region; and

wherein the first semiconductor layer has the first conductivity.

15. The method of claim 1, further comprising:

forming a gate insulator over the third semiconductor layer;

forming a gate over the gate insulator;

forming a body region of a first conductivity in the third semiconductor layer adjacent the gate insulator;

forming a source region of a second conductivity disposed in the body region adjacent to the gate insulator;

forming a deep body region of the first conductivity in the second semiconductor layer adjacent the body region; and

wherein the first layer has the second conductivity.

16. The method of claim 1, further comprising:

forming a gate insulator over the third semiconductor layer;

forming a gate over the gate insulator;

forming a body region of a first conductivity in the third semiconductor layer adjacent the gate insulator;

forming a source region of a second conductivity disposed in the body region adjacent to the gate insulator;

forming a deep body region of the first conductivity in the second semiconductor layer adjacent the body region; and

wherein the first layer has the first conductivity.

17. The method of claim 1, further comprising:

forming a gate over the second semiconductor layer and adjacent the third semiconductor layer;

forming a body region of a first conductivity in the second semiconductor layer adjacent the gate; and

forming a source region of a second conductivity in the third semiconductor layer adjacent the body region.

18. The method of claim 1, wherein the semiconductor device comprises at least one of a MOS transistor, a junction field-effect transistor, and an insulated-gate bipolar transistor.

19. A method for making a semiconductor device comprising:

providing a first semiconductor layer having a first bandgap;

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forming a second semiconductor layer above the first semiconductor layer and having a second bandgap that is wider than the first bandgap, the second semiconductor layer comprising in stacked relation a first buffer layer, a second buffer layer, and a drift layer;

forming a third semiconductor layer above the second semiconductor layer and having the first bandgap;

forming a trench in the third semiconductor layer defining first and second opposing walls;

forming a first doped semiconductor region spaced from the first wall and extending from a bottom surface of the third semiconductor layer into the second semiconductor layer a first depth; and

forming a second doped semiconductor region spaced from the second wall and extending from the bottom surface of the third semiconductor layer into the second semiconductor layer the first depth.

20. The method of claim 19, wherein providing the first semiconductor layer comprises providing a first substrate, forming the second semiconductor layer comprises forming a second epitaxial layer, and forming the third semiconductor layer comprises forming a third epitaxial layer.

21. The method of claim 19, wherein the first semiconductor layer comprises silicon, the second semiconductor layer comprises silicon carbide, and the third semiconductor layer comprises silicon.

22. The method of claim 19, wherein the semiconductor device comprises at least one of a MOS transistor, a junction field-effect transistor, and an insulated-gate bipolar transistor.

23. A method for making a semiconductor device comprising:

providing a first silicon layer;

forming a second silicon carbide layer above the first silicon layer, the second silicon carbide layer comprising in stacked relation a first buffer layer, a second buffer layer, and a drift layer;

forming a third silicon layer above the second silicon carbide layer;

forming a trench in the third silicon layer defining first and second opposing walls;

forming a first doped semiconductor region spaced from the first wall and extending from a bottom surface of the third silicon layer into the second silicon carbide layer a first depth; and

forming a second doped semiconductor region spaced from the second wall and extending from the bottom surface of the third silicon layer into the second silicon carbide layer the first depth.

24. The method of claim 23, wherein the semiconductor device comprises at least one of a MOS transistor, a junction field-effect transistor, and an insulated-gate bipolar transistor.

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